

Date: Monday, 9/18/2006 2:30:32 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: PEDAL ASSEMBLY		
Job Number	28642	Part Number	: D412704041		
Estimate Number	11005	Drawing Number	: IIN-D412-704 PG6,11		
P.O. Number	N/A	Project Number	: N/A		
This Issue	9/18/2006	S.O. No.	: N/A		
Prsh Rev.	NC	Type	: SMALL /MED FAB		
First Issue	N/A				
Previous Run	26150	Material	: N/A		
Written By		Due Date	: 9/30/2006		
Checked & Approved By		Qty:	4		
Comment	: Est Rev:B 05.04.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF Est Rev:C 06.03.08 Re-format EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble pedal as per Dwg IIN-D412-704 and Figures 1-3 Note: Only engage one thread on each bolt.			
FF 06-10-12			
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Pick Packing Kit			
3.0	D3204041	Pedal Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: ✓ Qty Part number Description batch 1 D3204-041 Pedal Assembly B23524			
FF 06-10-12			
4.0	D32051	Bracket	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: ✓ Qty Part number Description batch 1 D3205-1 Bracket B25964			
FF 06-10-12			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services				Drawing Name: PEDAL ASSEMBLY		
Job Number: 28642				Part Number: D412704041		
Job Number: 						
Seq. #:	Machine Or Operation:		Description :			
5.0	D32053		Back Plate			
						
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)						
Pick:						
Qty Part number Description batch				<i>B26001</i>		
1 D3205-3 GHW Bracket				<i>FF 06-10-12</i>		
6.0	D32061		Pedal Arm			
						
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)						
Pick:						
Qty Part number Description batch				<i>B26153</i>		
1 D3206-1 Pedal arm				<i>PTO FF 06-10-12</i>		
7.0	D3209041		Bracket			
						
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)						
Pick:						
Qty Part number Description batch				<i>B23527</i>		
1 D3209-041 Bracket				<i>FF 06-10-12</i>		
8.0	AN310A		Bolt			
						
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)						
Pick:						
Qty Part number Description batch				<i>M17566</i>		
1 AN3-10A Bolt				<i>FF 06-10-12</i>		
9.0	AN3154R		Nut			
						
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)						
Pick:						
Qty Part number Description batch				<i>M17566</i>		
1 AN315-4R Nut				<i>FF 06-10-12</i>		

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-12	6.0	Part D3206-1 ϕ 0.191 holes are out of tolerance ϕ 0.180	P4 per DSI 042	Drill out holes to ϕ 0.191 deburr and touch up I.A.W D3206-1 Rev H.	P4 per QSI 042 06-10-12	P4 per QSI 042 06-10-12	P4 per QSI 042 06-10-12	P4 per QSI 042 06-10-12

NOTE: Date & initial all entries

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Drawing Name: PEDAL ASSEMBLY

Job Number: 28642

Part Number: D412704041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 AN410A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

✓ Qty Part number Description batch
1 AN4-10A Bolt M 17073

FF 06-10-12

4

11.0 AN412A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

✓ Qty Part number Description batch
2 AN4-12A Bolt M 101390

FF 06-10-12

4

12.0 AN413A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

✓ Qty Part number Description batch
1 AN4-13A Bolt M 101938

FF 06-10-12

4

13.0 AN960JD10 Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

✓ Qty Part number Description batch
5 AN960JD10 Washer M 100743

FF 06-10-12

4

14.0 AN960JD416 Washer



Comment: Qty.: 11.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

✓ Qty Part number Description batch
11 AN960JD416 Washer M 19185

FF 06-10-12

4

15.0 AN960JD416L Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

✓ Qty Part number Description batch
3 AN960JD416L Washer M 101237

FF 06-10-12

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services			Drawing Name: PEDAL ASSEMBLY		
Job Number: 28642			Part Number: D412704041		
Job Number: 					
Seq. #:	Machine Or Operation:		Description :		
16.0	MS21042L3		Nut 		
Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)					
Pick: ✓ Qty Part number Description batch <u>M101390</u> FF 06-10-12 4					
17.0	MS21042L4		Nut 		
Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)					
Pick: ✓ Qty Part number Description batch <u>M19099</u> FF 06-10-12 4					
18.0	MS24694S102		Screw 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)					
Pick: ✓ Qty Part number Description batch <u>M14604</u> FF 06-10-12 4					
19.0	MS951910		Bolt 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)					
Pick: ✓ Qty Part number Description batch <u>M100290</u> FF 06-10-12 4					
20.0	AN960JD10L		Washer 		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)					
Pick: ✓ Qty Part number Description batch <u>M101291</u> FF 06-10-12 4					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/10/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: PEDAL ASSEMBLY

Job Number: 28642

Part Number: D412704041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0 AN36A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part number Description
2 AN3-6A Bolt

batch
110950

FF 06-10-12

4

22.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

23.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57492

06/10/20 (4)

24.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/20 (4)

Job Completion



06/10/20 (4)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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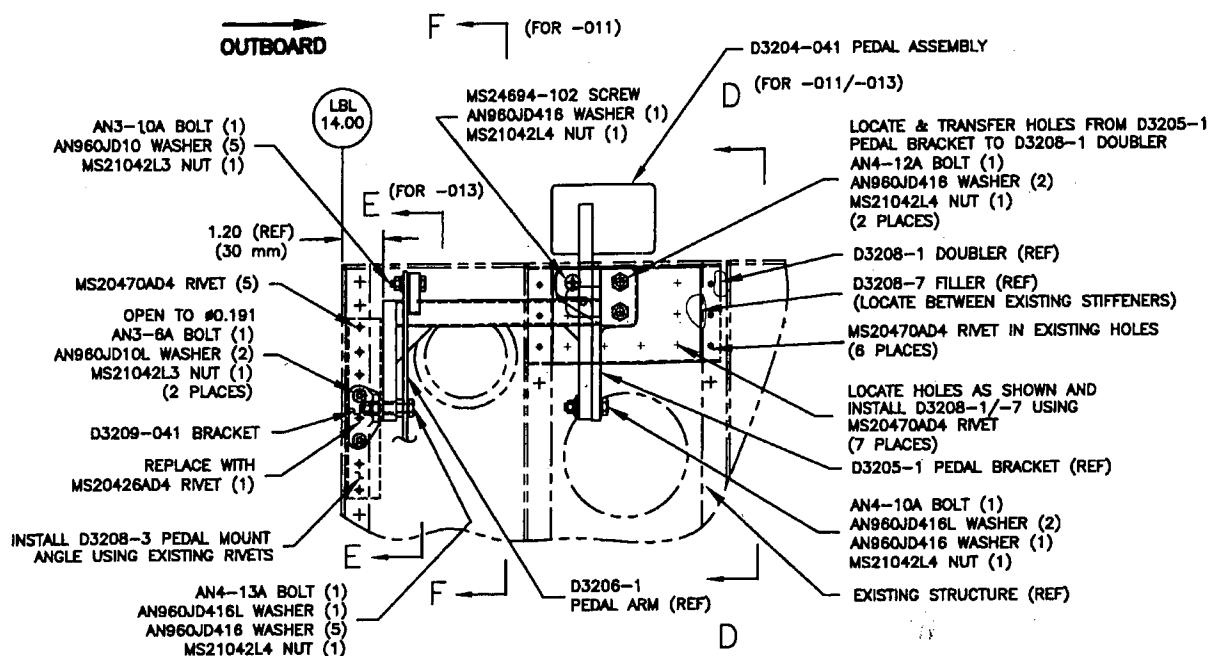


Figure 2 – Detail A. View looking AFT
(Co-pilot's Side -011/-013 Installations).

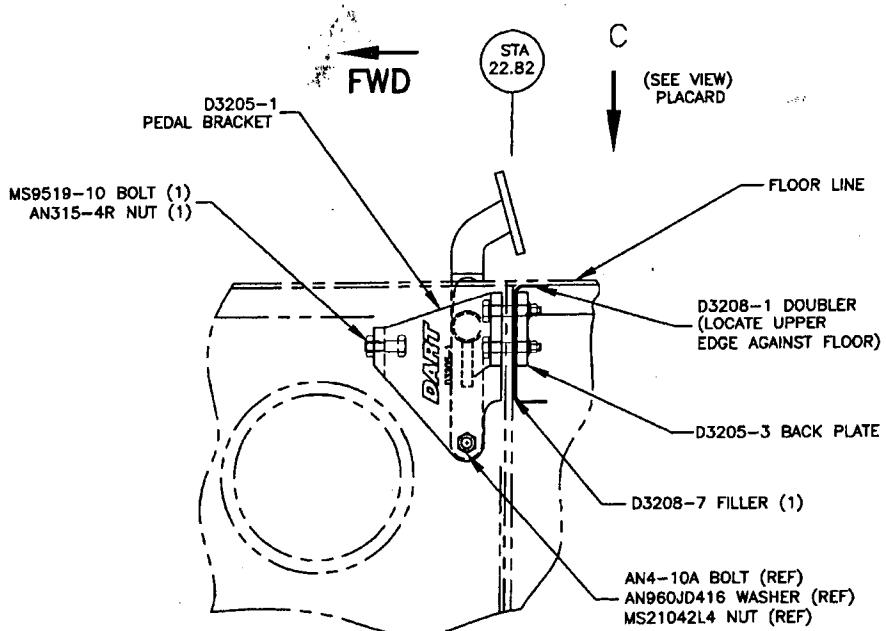


Figure 3 – View D-D. View looking Inboard
(-011/-013 Installations)

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Revision: A
Date: 04.02.03

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Qty -045	Part Number	Description
X					D412-704-011	COPilot's EMERGENCY CARGO RELEASE KIT (BELL 212/ 214 / 412)
	X				D205-704-013	COPilot's EMERGENCY CARGO RELEASE KIT (BELL 205)
1	1	X			D412-704-041	PEDAL ASSEMBLY (205/ 212/ 214/ 412)
	1		X		D205-704-043	CABLE ASSEMBLY (205)
1				X	D412-704-045	CABLE ASSEMBLY (212/ 214/ 412)
					D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
					D3205-1	PEDAL BRACKET (OR ECM 999703-1)
					D3205-3	BACK PLATE (OR ECM 999709-5)
					D3206-1	PEDAL ARM (OR ECM 999704-1)
					D3207-1	BRACKET
1					D3207-2	BRACKET
	1				D3207-3	BRACKET
1					D3207-5	BRACKET
1	1				D3208-1	DOUBLER (OR ECM 999709-1)
1					D3208-11	FILLER
1	1				D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1				D3208-5	MOUNT ANGLE
1	1				D3208-7	FILLER (OR ECM 999709-3)
1					D3208-9	DOUBLER
		1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1				D3214-1	PLACARD (OR ECM 999712-1)
			1		D3217-1	CABLE
				1	D3217-3	CABLE
			1	1	D3257-1	FITTING
			1	1	D3258-1	ANGLE BRACKET
					AN315-4R	NUT
5	2	2			AN960JD10	WASHER
4	2	2			AN960JD10L	WASHER
11					AN960JD416	WASHER
3					AN960JD416L	WASHER
			3	3	NAS509-3	NUT
			3	2	MS21042L3	NUT (OR MS21042-3)
				5	MS21042L4	NUT (OR MS21042-4)
4	4				MS21919DG5	CLAMP
		1			MS24694-S102	SCREW
2					MS35489-10	GROMMET
			1	1	AN3-5A	BOLT
		2			AN3-6A	BOLT
		1			AN3-10A	BOLT
			1	1	AN3-13A	BOLT
			1		MS9519-10	BOLT
			1		AN4-10A	BOLT
		2			AN4-12A	BOLT
		1			AN4-13A	BOLT

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Revision: A

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